

(19)



(11)

EP 2 425 956 B1

(12)

EUROPEAN PATENT SPECIFICATION

(45) Date of publication and mention of the grant of the patent:
29.06.2016 Bulletin 2016/26

(51) Int Cl.:
B29C 45/16 ^(2006.01) **B29C 45/14** ^(2006.01)
H01Q 1/24 ^(2006.01)

(21) Application number: **11179761.9**

(22) Date of filing: **01.09.2011**

(54) Injection molded case having antenna pattern and manufacturing method thereof

Spritzgussgeformtes Gehäuse mit Antennenmuster und Herstellungsverfahren dafür

Boîtier moulé par injection doté d'un motif d'antenne et son procédé de fabrication

(84) Designated Contracting States:
AL AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO PL PT RO RS SE SI SK SM TR

- **Oh, Jae-Ho**
442-742 Gyeonggi-do (KR)
- **Koo, Jeong-Woon**
442-742 Gyeonggi-do (KR)

(30) Priority: **07.09.2010 KR 20100087421**

(74) Representative: **Gover, Richard Paul et al**
HGF Limited
Saviour House
9 St Saviourgate
York YO1 8NQ (GB)

(43) Date of publication of application:
07.03.2012 Bulletin 2012/10

(73) Proprietor: **Samsung Electronics Co., Ltd.**
Suwon-si, Gyeonggi-do, 443-742 (KR)

(56) References cited:
US-A1- 2006 232 484 US-A1- 2009 322 629
US-A1- 2010 039 347

(72) Inventors:
 • **Ahn, Hae-Won**
442-742 Gyeonggi-do (KR)

EP 2 425 956 B1

Note: Within nine months of the publication of the mention of the grant of the European patent in the European Patent Bulletin, any person may give notice to the European Patent Office of opposition to that patent, in accordance with the Implementing Regulations. Notice of opposition shall not be deemed to have been filed until the opposition fee has been paid. (Art. 99(1) European Patent Convention).

Description

BACKGROUND OF THE INVENTION

1. Field of the Invention

[0001] The present invention relates to an injection-molded case and a manufacturing method thereof. More particularly, the present invention relates to an injection molded case and manufacturing method in which antenna patterns are formed in the injection-molded case.

2. Description of the Related Art

[0002] In general, "a portable communication device" refers to a device with which a user performs wireless communications with another party. Such a portable communication device generally includes an HHP, a CT-2 cellular phone, a digital phone, a PCS phone, a PDA, etc., and can be further classified into various types of devices according to the appearance. For example, a wireless terminal is classified into one of a bar-type, flip-type, folder-type, and slide-type of wireless terminals according to appearance. The above enumerated conventional portable communication devices are necessarily provided with an antenna device, a data input/output device, and a data transmitting/receiving device. Naturally, as the data input device, a keypad through which data can be input mainly by a finger-pressing operation is generally used.

[0003] Portable communication devices have become smaller and lighter with each generation of devices. Accordingly, an antenna device applied to the portable communication device also has become smaller, and an internal antenna which can be embedded in the communication device has become the typical antenna used in such devices, whereas a few years back users had antennas physically extending from the portable communication device.

[0004] As shown in FIGs. 1 to 3, the process of mounting the internal antenna 2 at the inner side of a battery cover part 1 of the portable communication device will be described below.

[0005] First, as shown in FIG. 1, in the mounting of the internal antenna 2, a metallic sheet is cut by a press process to fabricate an antenna pattern 2a, and then as shown in FIG. 2, the antenna pattern 2a is integrally mounted in an injection-molded article 2b by a first-insert injection molding process. As shown in FIG. 3, the injection-molded article 2b mounted with the antenna pattern 2a is integrally mounted in the battery cover part 1 of the portable communication device by a second insert injection molding process.

[0006] As described above, since it is not easy to fix the antenna pattern 2a, the conventional mounting process is divided into two steps. In other words, the process is carried out by first and second insert injection molding processes.

[0007] Also, as shown in FIGs. 4 to 6, the process of mounting the internal antenna 20 at the inner side of a rear case 10 of the portable communication device will be described below.

5 [0008] First, as shown in FIG. 4, in the mounting of the internal antenna 20, a metallic sheet is cut by a press process in accordance with the shape of the portable communication device so as to fabricate an antenna pattern 20a, and then as shown in FIG. 5, the antenna pattern 20a is integrally mounted in an injection-molded article 20b by a first insert injection molding process. As shown in FIG. 6, the injection-molded article 20b mounted with the antenna pattern 20a is integrally mounted in the rear case 10 of the portable communication device by a second insert injection molding process.

[0009] Likewise, since it is not easy to fix the antenna pattern 20a, the mounting process is divided into two steps. In other words, the process is carried out by first and second insert injection molding processes.

20 [0010] However, a conventional internal antenna device has a problem in that a manufacturing cost of a product is increased due to a complicated manufacturing process and an increase of a manufacturing time because an antenna pattern is fabricated by a press process and then is formed in an injection-molded article, a battery cover part, or a rear case of a communication device through first and second insert injection molding processes.

25 [0011] US-2010/039347-A1 discloses a housing according to the preamble of claim 1, functioning as an antenna including an antenna base including two protruding flanges. The housing is formed by injection molding a molten plastic material over and around the antenna base, whereby the antenna base is embedded in the housing, and the protruding flanges are exposed out of the housing. A method for fabricating the housing is also described.

30 [0012] US-2009/322629-A1 discloses a cover adapted to a communication device, a communication device including the same and a method for manufacturing the same. The cover according to the invention includes a cover body and an antenna. The cover body has a bottom surface. Particularly, the antenna is fixed at a predetermined position on the bottom surface by an insert molding process.

35 [0013] Accordingly, there is required a method for forming the antenna pattern in a battery cover part and a rear case by only one insert injection molding process, instead of a method for forming the antenna pattern in the battery cover part and the rear case by first and second insert injection molding processes.

SUMMARY OF THE INVENTION

40 [0014] Embodiments of the present invention provide an injection-molded case having antenna patterns and the manufacturing method thereof, in which antenna patterns are formed in the injection-molded case by only one

(i.e. single) insert injection molding process, unlike a conventional technology where antenna patterns are formed in an injection-molded case by first insert and second insert injection molding processes. Since an additional insert injection molding process is not required, the present invention reduces a manufacturing process and a manufacturing time of a product. Also, since it is not required to manufacture an additional (i.e. second) mold, it is possible to reduce a manufacturing cost of a product.

[0015] In accordance with a first aspect of the present invention, there is provided an injection-molded case according to claim 1 having one or more antenna patterns, the injection-molded case comprising: one or more antenna patterns fabricated by a press process; and an injection-molded case having the antenna patterns provided therewithin, in which the injection molded case is fabricated by fixing the antenna patterns on an injection mold and performing single insert injection molding process; wherein each antenna pattern comprises one or more first fixing holes formed in the antenna pattern arranged to fixedly couple with at least one of ribs or fixing protrusions formed on an injection mold, one or more second fixing holds formed at positions adjacent to the first fixing holes in the antenna patterns, in which the one or more second fixing holds are arranged to fixedly couple with ribs or fixing protrusions formed on the injection-molded case after the single insert injection molding process, and one or more third fixing holes formed with jaws arranged to receive an injected resin inserted into the jaws during the single insert injection molding process such that the resin rises in and over the jaws of the third fixing holes so as to fix the antenna patterns in place within the injection-molded case.

[0016] In accordance with a second aspect of the present invention, there is provided a method according to claim 5 for manufacturing an injection-molded case having one or more antenna patterns, the method comprising the steps of: fabricating one or more antenna patterns fabricated by a press process; and fabricating an injection-molded case having the antenna patterns provided therewithin by fixing the antenna patterns on an injection mold and performing a single insert injection molding process; wherein in step each antenna pattern is formed with one or more first fixing holes for being fixedly coupled with ribs or fixing protrusions formed on the injection mold, one or more second fixing holes formed for being fixedly coupled with ribs or fixing protrusions formed on the injection-molded case part after the insert injection molding process, and one or more third fixing holes, which are formed with jaws and in step the resin of the injection is received in the jaws such that the resin rises in and over the jaws of the third fixing holes so as to fix the antenna patterns.

BRIEF DESCRIPTION OF THE DRAWINGS

[0017] The above and other aspects, features and advantages of the present invention will become more ap-

parent from the following detailed description taken in conjunction with the accompanying drawings, in which Figures 1 to 6 illustrate features of conventional antenna patterns, Figures 7 to 11 and 18 illustrate embodiments of the present invention and Figures 12 to 17 illustrate additional embodiments of similar subject matter. In detailed summary:

FIG. 1 is a view illustrating a conventional antenna pattern fabricated by a press process;

FIG. 2 is a view illustrating a state where a conventional antenna pattern is formed on an injection-molded article by a first insert injection molding process;

FIG. 3 is a view illustrating a state where a conventional injection-molded article formed by a first insert injection molding process is formed at the inner side of a battery cover part of a portable communication device by a second insert injection molding process;

FIG. 4 is a view illustrating a conventional antenna pattern designed to be provided in a rear case of a portable communication device;

FIG. 5 is a view illustrating a state where an antenna pattern shown in FIG. 4 is formed on an injection-molded article by a first insert injection molding process that is the first part of the conventional process;

FIG. 6 is a view illustrating a state where an injection-molded article formed by a first insert injection molding process, shown in FIG. 5, is formed at the inner side of a rear case of a portable communication device by a second insert injection molding process that is the second part of the conventional process;

FIG. 7 is a view illustrating an antenna pattern to be configured in a battery cover part of a portable communication device, according to an exemplary embodiment of the present invention;

FIG. 8 is a view illustrating a state where an antenna pattern shown in FIG. 7 is provided at the inner side of a battery cover part of a portable communication device by an insert injection molding process according to the present invention;

FIG. 9 is a view illustrating a state where a sheet part is attached on an antenna pattern provided at the inner side of a battery cover part of a portable communication device, according to an exemplary embodiment of the present invention;

FIG. 10 is a cut-away view illustrating a third fixing hole of an antenna pattern provided at the inner side of a battery cover part of a portable communication device, according to an exemplary embodiment of the present invention;

FIG. 11 is a view illustrating an injection mold of a battery cover part of a portable communication device, according to an exemplary embodiment of the present invention;

FIG. 12 is a view illustrating antenna patterns to be configured in a rear case of a portable communication device;

FIG. 13 is a view illustrating a state where antenna patterns shown in FIG. 12 are provided at the inner side of upper and lower portions of a rear case of a portable communication device by an insert injection molding process;

FIG. 14 is a view illustrating the inner side of an upper portion of a rear case of a portable communication device;

FIG. 15 is a view illustrating the inner side of a lower portion of a rear case of a portable communication device;

FIG. 16 is a view illustrating the upper side of an injection mold of a rear case of a portable communication device

FIG. 17 is a view illustrating the lower side of an injection mold of a rear case of a portable communication device; and

FIG. 18 is a flow diagram illustrating a method for manufacturing an injection-molded case provided with antenna patterns according to an exemplary embodiment of the present invention.

DETAILED DESCRIPTION

[0018] Hereinafter, preferred exemplary embodiments of the present invention will be described in detail with reference to the accompanying drawings. The exemplary embodiments and configurations disclosed and shown in the drawings herein are only exemplary preferred embodiments of the present invention. It should be understood that various modifications replacing these can exist at the time of application.

[0019] As shown in FIGs. 7 to 17, an injection-molded case 100 provided with antenna patterns preferably includes one or more antenna patterns 110, and an injection-molded case 120 (shown in FIG. 8). The antenna patterns 110 are fabricated by a press process, and the injection-molded case 120 is provided with the antenna patterns 110 therewithin, in which the antenna patterns 110 are fixed on an injection mold 130 (FIG. 11) and subjected to an insert injection molding process.

[0020] As shown in FIGs. 7 to 10, the antenna patterns 110 preferably include one or more first fixing holes 111, one or more second fixing holes 112, and one or more third fixing holes 113. The first fixing holes 111 are formed in the antenna pattern 110 such that they can be fixedly coupled with ribs 132 or fixing protrusions formed on the injection mold 130 (FIG. 132). The second fixing holes 112 are formed preferably at positions adjacent to the first fixing holes 111 in such that they can be fixedly coupled with ribs 121 (FIG. 8) or fixing protrusions formed on the injection-molded case 120 after the insert injection molding process.

[0021] As shown in FIG. 10, the third fixing holes 113 are formed with jaws 113a, and are formed preferably at positions adjacent to the first and second fixing holes 111 and 112 in such a manner that an injected resin A1 can be inserted into the jaws 113a after the single insert in-

jection molding process.

[0022] The surface of the antenna patterns 110 is designed in such that after the single insert injection molding process, the resin A1 is injected to cover and fix the antenna patterns 110.

[0023] As shown in FIG. 11, in the injection mold 130, a guide rail 131 is formed. The guide rail fixes the antenna patterns 110, and during the single insert injection molding process, prevents the antenna patterns 110 from becoming loosened or displaced by the resin A1, while guiding the resin A1 in such a manner that the resin A1 can cover the antenna patterns 110. In the injection mold 130, one or more magnetic parts 140 are provided in such a manner that they can fix the antenna patterns 110 by a magnetic force so as to prevent the antenna patterns 110 from escaping during the single insert injection molding process. Also, in the injection mold 130, fixing ribs 133 are formed in order to fix and seat the antenna patterns 110.

[0024] As shown in FIG. 11, the guide rail 131 preferably includes a guide groove.

[0025] As shown in FIGs. 8 and 9, the injection-molded case 120 includes a battery cover portion 123. Also, the injection-molded case 120 may include another cover portion beside the battery cover portion (e.g., a terminal cover portion, an earphone cover portion, etc.).

[0026] As shown in FIG. 9, on the externally exposed surface of the antenna patterns 110 provided in the battery cover portion 123, a sheet portion 122 is attached in so that the sheet portion can protect the antenna patterns 110.

[0027] The sheet portion 122 is made of a poly carbonate (PC), and may be made of another material than the PC (e.g., a silicon material, etc.).

[0028] Also, as shown in FIGs. 12 to 17, the injection-molded case includes a rear case 200 of a portable communication device. Also, the injection-molded case may include another case portion beside the rear case 200 (e.g., an upper case, etc.).

[0029] The injection-molded case is preferably configured such that by only one insert injection molding process (i.e. a single insert injection molding process), the rear case 200 is fabricated, and antenna patterns 210 are provided at the inner side of upper and lower portions of the rear case 200.

[0030] Referring to FIG.; 13, in the rear case 200, seating ribs 201 are formed so as to seat the antenna patterns 210.

[0031] Meanwhile, according to an exemplary embodiment of the present invention, the injection-molded case 120 and 200 provided with the antenna patterns 110 and 210 representatively include the battery cover portion 123 and the rear case 200 of a portable communication device. However, the injection-molded case 120, 200 according to the present invention is not limited to the battery cover 123 and the rear case 200, and may be applied to various types of battery covers and rear cases (e.g., a bar-type portable communication device, a folder-type

portable communication device, a sliding-type portable communication device, a swing-type portable communication device, etc.).

[0032] Examples of a portable communication device according to the above described exemplary embodiment of the present invention may include not only all mobile communication terminals which operate in accordance with communication protocols corresponding to various communication systems, but also all information communication devices and multimedia devices (such as a portable multimedia player (PMP), an MP3 player, a navigation device, a game device, a notebook computer, an advertisement panel, a TV, a digital broadcast player, a personal digital assistant (PDA), a smart phone, a waterproof phone), and their application devices, just to name some non-limiting examples.

[0033] Hereinafter, the operation process of an injection-molded case provided with antenna patterns according to one preferred exemplary embodiment of the present invention, with the above described configuration, will be described in more detail with reference to FIGs. 7 to 17.

[0034] As shown in FIGs. 7 to 11, the injection-molded case 100 includes one or more antenna patterns 110, and the injection-molded case 120.

[0035] As shown in FIG. 7, the antenna patterns 110 are fabricated by a press process. Herein, in the antenna patterns 110, one or more first fixing holes 111, one or more second fixing holes 112, and one or more third fixing holes 113 are formed. The first fixing holes 111 are designed to be fixedly coupled with the ribs 132 formed on the injection mold 130. The second fixing holes 112 are designed to be fixedly coupled with the ribs 121 formed on the injection-molded case 120 after the single insert injection molding process. The third fixing holes 113 are formed with the jaws 113a in such a manner that the injected resin A1 can be inserted into the jaws 113a after the insert injection molding process.

[0036] As shown in FIG. 11, the first fixing holes 111 of the antenna patterns 110 are used to fix the antenna patterns with the injection mold 130. Also, when the resin A1 comes into the injection mold 130, the magnetic force of the magnetic parts 140 provided in the injection mold 130 fix the antenna patterns 110 while preventing them from escaping. Also, the antenna patterns 100 are fixed with and seated on the fixing ribs 133 formed on the injection mold 130.

[0037] In this state, as shown in FIG. 8, by performing only one insert injection molding process (i.e. a single insert injection molding process), the injection-molded case 120 is fabricated and the antenna patterns 110 are provided at the inner side of the injection-molded case 120.

[0038] Herein, as shown in FIG. 11, the injected resin A1 comes into the injection mold 130 along the guide rail 131 formed in the injection mold 130.

[0039] The guide rail 131 prevents the antenna patterns 110 from becoming loosened by the injected resin

A1, while guiding the resin A1 in such a manner that the resin R can cover the antenna patterns 110.

[0040] Herein, the ribs 121 formed on the injection-molded case 120 are fixedly coupled with the second fixing holes 112 of the antenna patterns 110.

[0041] Also, during the single insert injection molding process, the resin A1 is inserted into the jaws 113a of the third fixing holes 113 of the antenna patterns 110 and rises while fixing the antenna patterns 110.

[0042] Herein, as shown in FIG. 10, the resin A1 rises in the jaws 113a of the third fixing holes 113, thereby forming a "T" shape.

[0043] Herein, as shown in FIG. 9, the injection-molded case 120 includes a battery cover of a portable communication device. On the externally exposed surface of the antenna patterns 110 provided within the battery cover portion 123, the sheet part 122 is attached.

[0044] Also, as shown in FIGs. 12 to 17, the injection-molded case preferably includes the rear case 200 of a portable communication device. Also, in the upper and lower portions of the rear case 200, the antenna patterns 210 are provided.

[0045] Likewise, as shown in FIG. 12, the antenna patterns 210 are preferably fabricated by a press process.

[0046] Herein, as shown in FIGs. 16 to 17, in the antenna patterns 210 (such as shown in FIG. 12), one or more first fixing holes 211 are formed, which are to be fixedly coupled with the fixing protrusions 301 formed on an injection mold 300. Also, in the antenna patterns 210, one or more second fixing holes 212 are formed, which are to be fixedly coupled with fixing protrusions 202 formed on the rear case 200 after the single insert injection molding process. The first fixing holes 211 of the antenna patterns 210 are used to fix the antenna patterns with the injection mold 300.

[0047] Also, when the resin A1 comes into the injection mold 300, the magnetic force of magnetic parts (not shown) provided in the injection mold 300 fix the antenna patterns 210 while preventing them from movement.

[0048] In this state, as shown in FIGs. 13 to 17, by only one insert injection molding process, the rear case 200 is fabricated and the antenna patterns 210 are provided in the upper and lower portions at the inner side of the rear case 200.

[0049] Herein, as shown in FIGs. 14 to 15, the fixing protrusions 202 formed on the rear case 200 are fixedly coupled with the second fixing holes 212 of the antenna patterns 210, and the resin A1 rises and covers the surface of the second fixing holes 212.

[0050] The seating ribs 201 formed on the rear case 200 seat the antenna patterns 210 while avoiding interference with another component (not shown) of a portable communication device.

[0051] Hereinafter, the fabrication method and the operation process of an injection-molded case provided with antenna patterns according to one preferred exemplary embodiment of the present invention, with the above described configuration, will now be described in

more detail with reference to FIG. 18.

[0052] As shown in FIGs. 7 to 11, and the flowchart of FIG. 18, in the fabrication method of an injection-molded case, antenna patterns 110 are preferably fabricated by a press process in step S1.

[0053] Herein, as shown in FIG. 7, in the antenna patterns 110, one or more first fixing holes 111, one or more second fixing holes 112, and one or more third fixing holes 113 are formed. The first fixing holes 111 are designed to be fixedly coupled with the ribs 132 formed on the injection mold 130. The second fixing holes 112 are designed to be fixedly coupled with the ribs 121 formed on the injection-molded case 120 after the single insert injection molding process. The third fixing holes 113 are formed with the jaws 113a in such that the injected resin A1 (shown in FIG. 10) of injection can be inserted into the jaws 113a after the single insert injection molding process.

[0054] As shown in FIG. 11, the first fixing holes 111 of the antenna patterns 110 from S1 are used to fix the antenna patterns with the injection mold 130. Also, when the resin A1 comes into the injection mold 130, the magnetic force of the magnetic parts 140 provided in the injection mold 130 fix the antenna patterns 110 while preventing them from escaping. Also, the antenna patterns 100 are fixed with and seated on the fixing ribs 133 formed on the injection mold 130.

[0055] In this state, as shown in FIG. 8, by only one insert injection molding process (i.e. a single insert injection molding process), the injection-molded case 120 is fabricated and the antenna patterns 110 are provided at the inner side of the injection-molded case 120, in step S2.

[0056] Herein, the injected resin A1 comes into the injection mold 130 along the guide rail 131 formed in the injection mold 130.

[0057] The guide rail 131 prevents the antenna patterns 110 from becoming loosened by the injected resin A1, while guiding the resin A1 such that the resin A1 can cover the antenna patterns 110.

[0058] Herein, the ribs 121 formed on the injection-molded case 120 are fixedly coupled with the second fixing holes 112 of the antenna patterns 110.

[0059] Also, as shown in FIG. 10, during the single insert injection molding process, the resin A1 is inserted into the jaws 113a of the third fixing holes 113 of the antenna patterns 110 and rises while fixing the antenna patterns 110. Herein, the resin A1 rises in/over the jaws 113a of the third fixing holes 113, thereby forming a "T" shape.

[0060] Herein, as shown in FIG. 9, the injection-molded case 120 preferably includes a battery cover portion 123 of a portable communication device. On the externally exposed surface of the antenna patterns 110 provided within the battery cover portion 123, the sheet portion 122 is attached.

[0061] Also, as shown in FIGs. 12 to 18, the injection-molded case part includes the rear case 200 of a portable

communication device. Also, in the upper and lower portions of the rear case 200, the antenna patterns 210 are provided.

[0062] Likewise, as shown in FIG. 12, one or more antenna patterns 210 are fabricated by a press process, in step S1.

[0063] Herein, as shown in FIGs. 16 to 17, in the antenna patterns 210, one or more first fixing holes 211 are formed, which are to be fixedly coupled with the fixing protrusions 301 formed on an injection mold 300. Also, in the antenna patterns 210, one or more second fixing holes 212 are formed, which are to be fixedly coupled with fixing protrusions 202 formed on the rear case 200 after the insert injection molding process.

[0064] The first fixing holes 211 of the antenna patterns 210 from step S1 are used to fix the antenna patterns with the injection mold 300.

[0065] In this state, as shown in FIGs. 13 to 15, by only one (i.e. single) insert injection molding process, in S2 the rear case 200 is fabricated and the antenna patterns 210 are provided at the inner side of the rear case 200.

[0066] Herein, as shown in FIGs. 14 to 15, the fixing protrusions 202 formed on the rear case 200 are fixedly coupled with the second fixing holes 212 of the antenna patterns 210, and the resin A1 rises over and covers the surface of the second fixing holes 212.

[0067] The seating ribs 201 formed on the rear case 200 seat the antenna patterns 210 while avoiding interference with another component (not shown) of a portable communication device.

[0068] As described above, in the present invention, antenna patterns are formed on an injection-molded case part by only one (i.e. single) insert injection molding process whereas in a conventional technology, antenna patterns are formed on an injection-molded case part by first insert and second insert injection molding processes. Thus, since an additional insert injection molding process is not required, it is possible to reduce a manufacturing process and a manufacturing time. Also, since as the present invention does not require the additional manufacture of a mold, it is possible to reduce a manufacturing cost of a product.

[0069] The injection-molded case having antenna patterns and the manufacturing method thereof, according to the present invention, as described above, are not limited to the above described exemplary embodiments and drawings. It will be apparent to those skilled in the art that the exemplary embodiment of the present invention may be modified, changed, and substituted in various types of terminals (e.g., sliding-type, swing-type, and waterproof terminals) in a number of ways that are within the scope of the appended claims.

[0070] While the invention has been shown and described with reference to certain exemplary embodiments thereof, it will be understood by those skilled in the art that various changes in form and details may be made therein without departing from the scope of the invention as defined by the appended claims.

Claims

1. An injection-molded case having one or more antenna patterns, the injection-molded case (100) comprising:

one or more antenna patterns (110) fabricated by a press process; and
 an injection-molded case (120) having the antenna patterns provided therewithin, in which the injection molded case is fabricated by fixing the antenna patterns on an injection mold (130) and performing single insert injection molding process;
 wherein each antenna pattern (110) comprises:

one or more first fixing holes (111) formed in the antenna pattern and arranged to fixedly couple with at least one of ribs (132) or fixing protrusions formed on an injection mold (130);

one or more second fixing holes (112) formed at positions adjacent to the first fixing holes in the antenna patterns, in which the one or more second fixing holes are arranged to fixedly couple with ribs (121) or fixing protrusions formed on the injection-molded case (120) after the single insert injection molding process; and

one or more third fixing holes (113) formed at positions adjacent to the first and second fixing holes in the antenna patterns, **characterized in that** the third fixing holes (113) are formed with jaws (113a) arranged to receive an injected resin (A1) inserted into the jaws (113a) during the single insert injection molding process such that the resin (A1) rises in and over the jaws of the third fixing holes (113) thereby forming a "T" shape, so as to fix the antenna patterns in place within the injection-molded case.

2. The injection-molded case as claimed in claim 1, wherein the injection-molded case part (120) comprises a battery cover (123) or a rear case (200) of a portable communication device.

3. The injection-molded case as claimed in claim 2, wherein in the rear case, seating ribs (201) for seating the antenna patterns (210) are formed.

4. The injection-molded case as claimed in claim 2, wherein a sheet part (122) is attached to an externally exposed surface of the antenna patterns provided in the battery cover, wherein the sheet part is made of a poly carbonate (PC).

5. A method for manufacturing an injection-molded

case having one or more antenna patterns, the method comprising the steps of:

(S1) fabricating one or more antenna patterns (110) fabricated by a press process; and
 (S2) fabricating an injection-molded case (120) having the antenna patterns provided therewithin by fixing the antenna patterns on an injection mold (130) and performing a single insert injection molding process;
 wherein in step (S1) each antenna pattern is formed with:

one or more first fixing holes (111) for being fixedly coupled with ribs (132) or fixing protrusions formed on the injection mold (130); one or more second fixing holes (112) are formed for being fixedly coupled with ribs (121) or fixing protrusions formed on the injection-molded case part (120) after the insert injection molding process; and
 one or more third fixing holes (113) formed at positions adjacent to the first and second fixing holes in the antenna patterns, which are formed with jaws (113a) and in step (S2) the resin (A1) of the injection is received in the jaws (113a) such that the resin (A1) rises in and over the jaws of the third fixing holes (113) thereby forming a "T" shape, so as to fix the antenna patterns.

6. The method as claimed in claim 5, wherein in step (S2), in the injection mold, a guide rail (131) is formed, which fixes the antenna patterns, and during the single insert injection molding process, prevents the antenna patterns from becoming loosened by the resin, while guiding the resin in such a manner that the resin covers the antenna patterns; wherein in the injection mold, one or more magnetic parts (140) are provided, which fix the antenna patterns by a magnetic force during the insert injection molding process; and
 wherein that the guide rail (131) comprises a guide groove.

7. The method as claimed in claim 5, wherein in step (S2), the injection-molded case part (120) comprises a battery cover part (123) or a rear case (200) of a portable communication device.

8. The method as claimed in claim 7, wherein in the rear case, seating ribs (201) for seating the antenna patterns (210) are formed.

9. The method as claimed in claim 7, wherein in step (S2) a sheet part(122) is attached on an externally exposed surface of the antenna patterns provided in the battery cover part, wherein the sheet part is made

of a poly carbonate.

Patentansprüche

1. Spritzgussgehäuse mit einem oder mehreren Antennenmustern, wobei das Spritzgussgehäuse (100) Folgendes umfasst:

ein oder mehrere Antennenmuster (110), die mit einem Pressvorgang hergestellt wurden; und ein Spritzgussgehäuse (120) mit den darin vorgesehenen Antennenmustern, wobei das Spritzgussgehäuse durch Befestigen der Antennenmuster an einer Spritzform (130) und Ausführen eines einzigen Umspritzformvorgangs hergestellt wird; wobei jedes Antennenmuster (110) Folgendes umfasst:

ein oder mehrere erste Befestigungslöcher (111), die in dem Antennenmuster ausgebildet und zum festen Koppeln mit Rippen (132) und/oder Befestigungsvorsprüngen angeordnet sind, die an einer Spritzform (130) ausgebildet sind;

ein oder mehrere zweite Befestigungslöcher (112), die an Positionen neben den ersten Befestigungslöchern in den Antennenmustern ausgebildet sind, wobei die ein oder mehreren zweiten Befestigungslöcher zum festen Koppeln mit Rippen (121) oder Befestigungsvorsprüngen angeordnet sind, die an dem Spritzformgehäuse (120) nach dem einzigen Umspritzformvorgang ausgebildet wurden; und

ein oder mehrere dritte Befestigungslöcher (113), die an Positionen neben den ersten und zweiten Befestigungslöchern in den Antennenmustern ausgebildet sind,

dadurch gekennzeichnet, dass die dritten Befestigungslöcher (113) mit Backen (113a) ausgebildet sind, die zum Aufnehmen eines injizierten Harzes (A1) ausgelegt sind, der bei dem einzigen Umspritzformvorgang in die Backen (113a) eingeführt wurde, so dass das Harz (A1) in den und über die Backen der dritten Befestigungslöcher (113) ansteigt, um dadurch eine "T"-Form zu bilden, um die Antennenmuster in dem Spritzformgehäuse festzuhalten.

2. Spritzformgehäuse nach Anspruch 1, wobei der Spritzformgehäuseteil (120) eine Batterieabdeckung (123) oder eines hinteren Gehäuses (200) eines tragbaren Kommunikationsgeräts umfasst.

3. Spritzformgehäuse nach Anspruch 2, wobei in dem

hinteren Gehäuse Sitzrippen (201) für den Sitz der Antennenmuster (210) ausgebildet sind.

4. Spritzformgehäuse nach Anspruch 2, wobei ein Paneel (122) an einer extern exponierten Fläche der in der Batterieabdeckung vorgesehenen Antennenmuster angebracht ist, wobei das Paneel aus einem Polycarbonat (PC) gefertigt ist.

5. Verfahren zur Herstellung eines Spritzgussgehäuses mit einem oder mehreren Antennenmustern, wobei das Verfahren die folgenden Schritte beinhaltet:

(S1) Herstellen von einem oder mehreren Antennenmustern (110) durch einen Pressvorgang; und

(S2) Herstellen eines Spritzgussgehäuses (120) mit den darin vorgesehenen Antennenmustern durch Befestigen der Antennenmuster an einer Spritzform (130) und Durchführen eines einzigen Umspritzformvorgangs;

wobei in Schritt (S1) jedes Antennenmuster gebildet wird mit:

einem oder mehreren ersten Befestigungslöchern (111) zum festen Koppeln mit Rippen (132) oder Befestigungsvorsprüngen, die an der Spritzform (130) ausgebildet sind;

einem oder mehreren zweiten Befestigungslöchern (112), die zum festen Koppeln mit Rippen (121) oder Befestigungsvorsprüngen ausgebildet sind, die an dem Spritzformgehäuseteil (120) nach dem Umspritzformvorgang ausgebildet wurden; und

einem oder mehreren dritten Befestigungslöchern (113), die an Positionen neben dem ersten und zweiten Befestigungslöcher in den Antennenmustern ausgebildet sind, die mit Backen (113a) ausgebildet sind, und in Schritt (S2) das Harz (A1) der Spritzung in den Backen (113a) so aufgenommen wird, dass das Harz (A1) in den und über die Backen der dritten Befestigungslöcher (113) ansteigt, um dadurch eine "T"-Form zu bilden, um die Antennenmuster zu befestigen.

6. Verfahren nach Anspruch 5, wobei in Schritt (S2), in der Spritzform, eine Führungsschiene (131) ausgebildet wird, die die Antennenmuster befestigt, und während des einzigen Umspritzformvorgangs verhindert wird, dass die Antennenmuster von dem Harz gelöst werden, während das Harz auf eine solche Weise geführt wird, dass das Harz die Antennenmuster bedeckt;

wobei in der Spritzform ein oder mehrere Magnet-

teile (140) vorgesehen sind, die die Antennenmuster durch eine Magnetkraft während des Umspritzformvorgangs befestigen; und wobei die Führungsschiene (131) eine Führungsnut umfasst.

7. Verfahren nach Anspruch 5, wobei in Schritt (S2) der Spritzformgehäuseteil (120) einen Batterieabdeckteil oder ein hinteres Gehäuse (200) eines tragbaren Kommunikationsgeräts umfasst.

8. Verfahren nach Anspruch 7, wobei im hinteren Gehäuse Sitzrippen (201) für den Sitz der Antennenmuster (210) ausgebildet sind.

9. Verfahren nach Anspruch 7, wobei in Schritt (S2) ein Paneel (122) an einer extern exponierten Fläche der in dem Batterieabdeckteil vorgesehenen Antennenmuster angebracht ist, wobei das Paneel aus einem Polycarbonat besteht.

Revendications

1. Boîtier moulé par injection possédant un ou plusieurs motifs d'antenne, le boîtier moulé par injection (100) comprenant :

un ou plusieurs motifs d'antenne (110) fabriqués par un processus à presse ; et un boîtier moulé par injection (120) dont les motifs d'antenne sont prévus à l'intérieur de celui-ci, dans lequel le boîtier moulé par injection est fabriqué en fixant les motifs d'antenne sur un moule d'injection (130) et en réalisant un processus unique de moulage par injection sur prisonnier ; cas dans lequel chaque motif d'antenne (110) comprend :

un ou plusieurs premiers trous de fixation (111) formés dans le motif d'antenne et agencés pour assurer un couplage fixe avec au moins un des postes, soit des nervures (132) soit des saillies de fixation formées sur un moule d'injection (130) ; un ou plusieurs deuxièmes trous de fixation (112) formés au niveau de positions adjacentes aux premiers trous de fixation dans les motifs d'antenne, dans lesquelles lesdits un ou plusieurs deuxièmes trous de fixation sont agencés pour assurer un couplage fixe avec des nervures (121) ou des saillies de fixation formées sur le boîtier moulé par injection (120) après le processus unique de moulage par injection sur prisonnier ; et un ou plusieurs troisièmes trous de fixation (113) formés au niveau de positions adja-

centes aux premiers et deuxièmes trous de fixation dans les motifs d'antenne, **caractérisé en ce que** les troisièmes trous de fixation (113) sont formés avec des mâchoires (113a) agencées de façon à :

recevoir une résine injectée (A1) insérée dans les mâchoires (113a) au cours du processus unique de moulage par injection sur prisonnier de sorte que la résine (A1) monte dans les mâchoires, et au-dessus de celles-ci, des troisièmes trous de fixation (113) permettant ainsi de former une forme en « T » de sorte à fixer les motifs d'antenne en place à l'intérieur du boîtier moulé par injection.

2. Boîtier moulé par injection selon la revendication 1, la partie du boîtier moulé par injection (120) comprenant un couvercle de batterie (123) ou un boîtier arrière (200) d'un dispositif de communication portable.

3. Boîtier moulé par injection selon la revendication 2, des nervures d'assise (201) pour asseoir les motifs d'antenne (210) étant formées dans le boîtier arrière.

4. Boîtier moulé par injection selon la revendication 2, une partie en feuille (122) étant attachée à une surface exposée vers l'extérieur des motifs d'antenne prévus dans le couvercle de batterie, cas dans lequel la partie en feuille est réalisée en un polycarbonate (PC).

5. Procédé de fabrication d'un boîtier moulé par injection possédant un ou plusieurs motifs d'antenne, le procédé comprenant les étapes consistant à :

(S1) fabriquer un ou plusieurs motifs d'antenne (110) fabriqués par un processus à presse ; et (S2) fabriquer un boîtier moulé par injection (120) dont les motifs d'antenne sont prévus à l'intérieur de celui-ci grâce à la fixation des motifs d'antenne sur un moule d'injection (130) et à la réalisation d'un processus unique de moulage par injection sur prisonnier ; cas dans lequel, lors de l'étape (S1), chaque motif d'antenne est formé avec :

un ou plusieurs premiers trous de fixation (111) afin d'être couplés de façon fixe avec des nervures (132) ou des saillies de fixation formées sur le moule d'injection (130) ; un ou plusieurs deuxièmes trous de fixation (112) sont formés afin d'être couplés de façon fixe avec des nervures (121) ou des saillies de fixation formées sur la partie du boîtier moulé par injection (120) après le processus de moulage par injection sur

- prisonnier ; et
un ou plusieurs troisièmes trous de fixation (113) formés au niveau de positions adjacentes aux premiers et deuxièmes trous de fixation dans les motifs d'antenne, lesquels sont formés avec des mâchoires (113a) et dans l'étape (S2), la résine (A1) de l'injection est reçue dans les mâchoires (113a) de sorte que la résine (A1) monte dans les mâchoires, et au-dessus de celles-ci, des troisièmes trous de fixation (113), permettant ainsi de former une forme en « T » de sorte à fixer les motifs d'antenne.
- 5
10
6. Procédé selon la revendication 5, dans l'étape (S2) est formé un rail de guidage (131) dans le moule d'injection, lequel fixe les motifs d'antenne, et pendant le processus unique de moulage par injection sur prisonnier, empêche un relâchement des motifs d'antenne par la résine tout en guidant la résine d'une manière telle que la résine recouvre les motifs d'antenne ;
cas dans lequel, une ou plusieurs parties magnétiques (140) sont prévues dans le moule d'injection lesquelles fixent les motifs d'antenne en vertu d'une force magnétique pendant le processus de moulage par injection sur prisonnier ; et
cas dans lequel le rail de guidage (131) comprend une rainure de guidage.
- 15
20
25
30
7. Procédé selon la revendication 5, dans l'étape (S2), la partie du boîtier moulé par injection (120) comprenant une partie à couvercle de batterie (123) ou un boîtier arrière (200) d'un dispositif de communication portable.
- 35
8. Procédé selon la revendication 7, des nervures d'assise (201) pour asseoir les motifs d'antenne (210) étant formées dans le boîtier arrière.
- 40
9. Procédé selon la revendication 7, dans l'étape (S2) une partie en feuille (122) étant attachée sur une surface exposée vers l'extérieur des motifs d'antenne prévus dans la partie à couvercle de batterie, cas dans lequel la partie en feuille est réalisée en un polycarbonate.
- 45
50
55

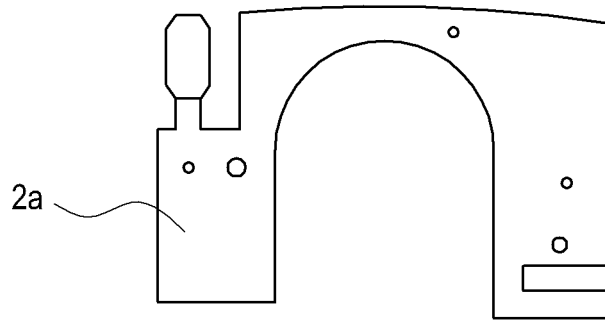


FIG. 1

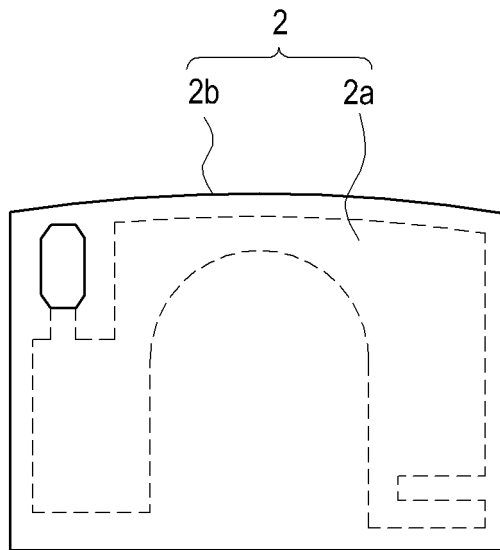


FIG. 2

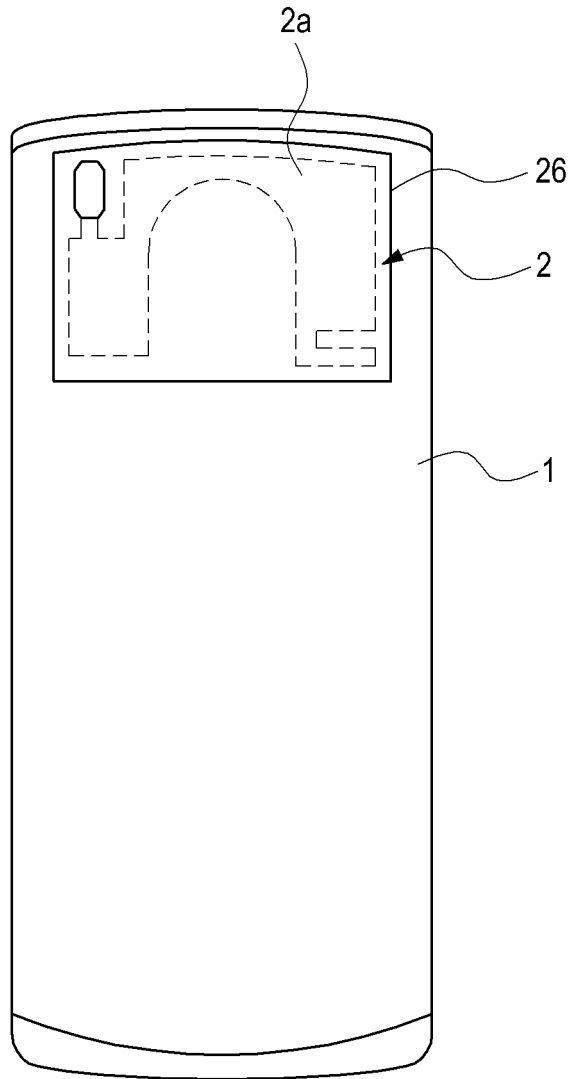


FIG.3

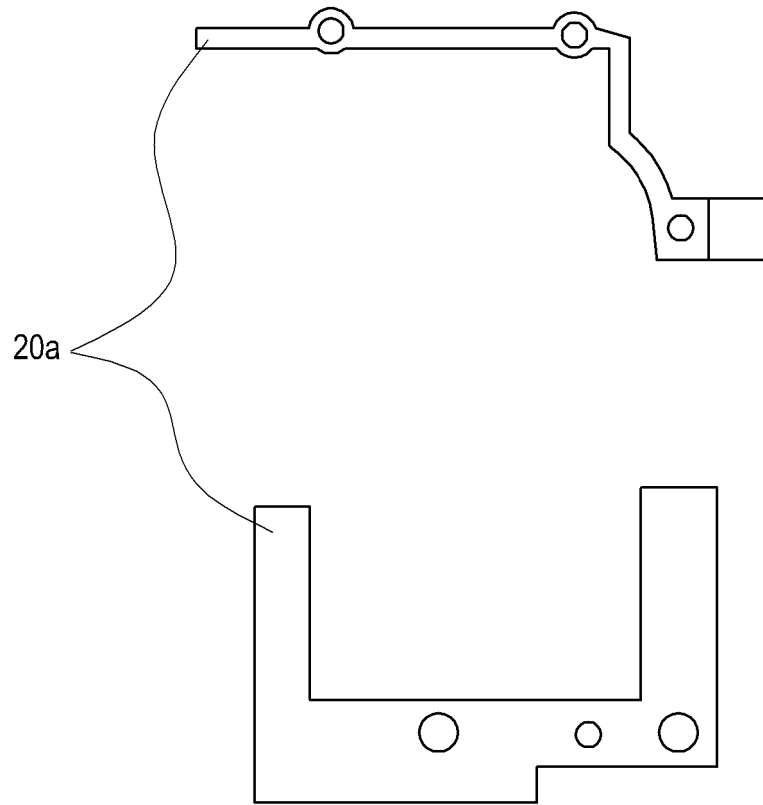


FIG.4

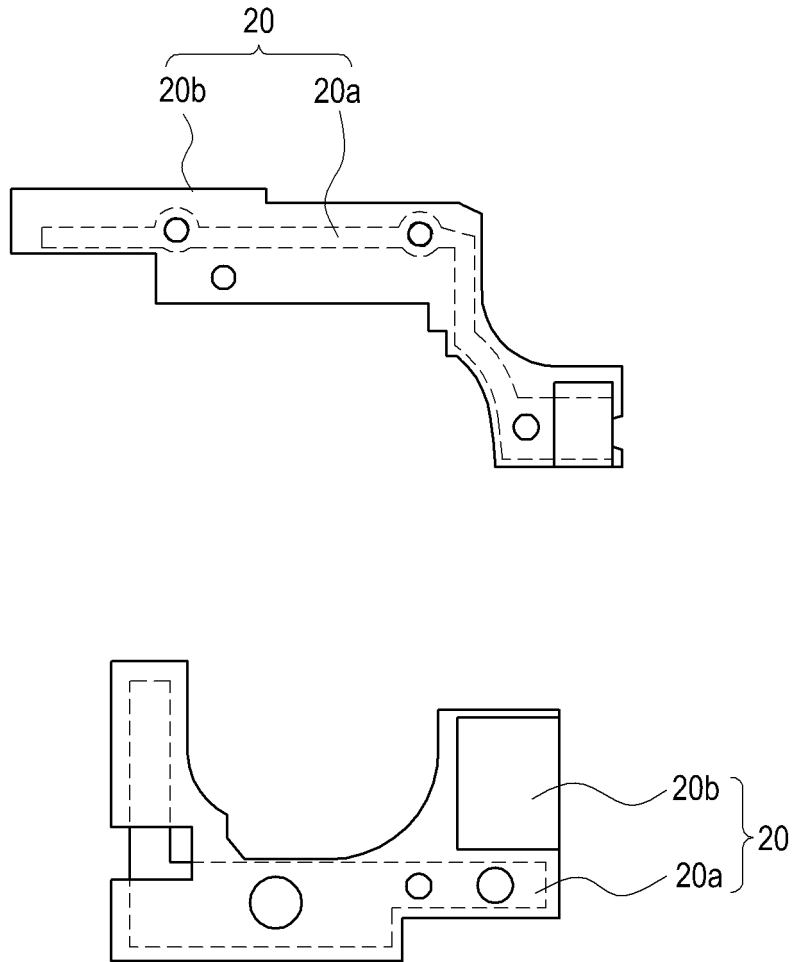


FIG.5

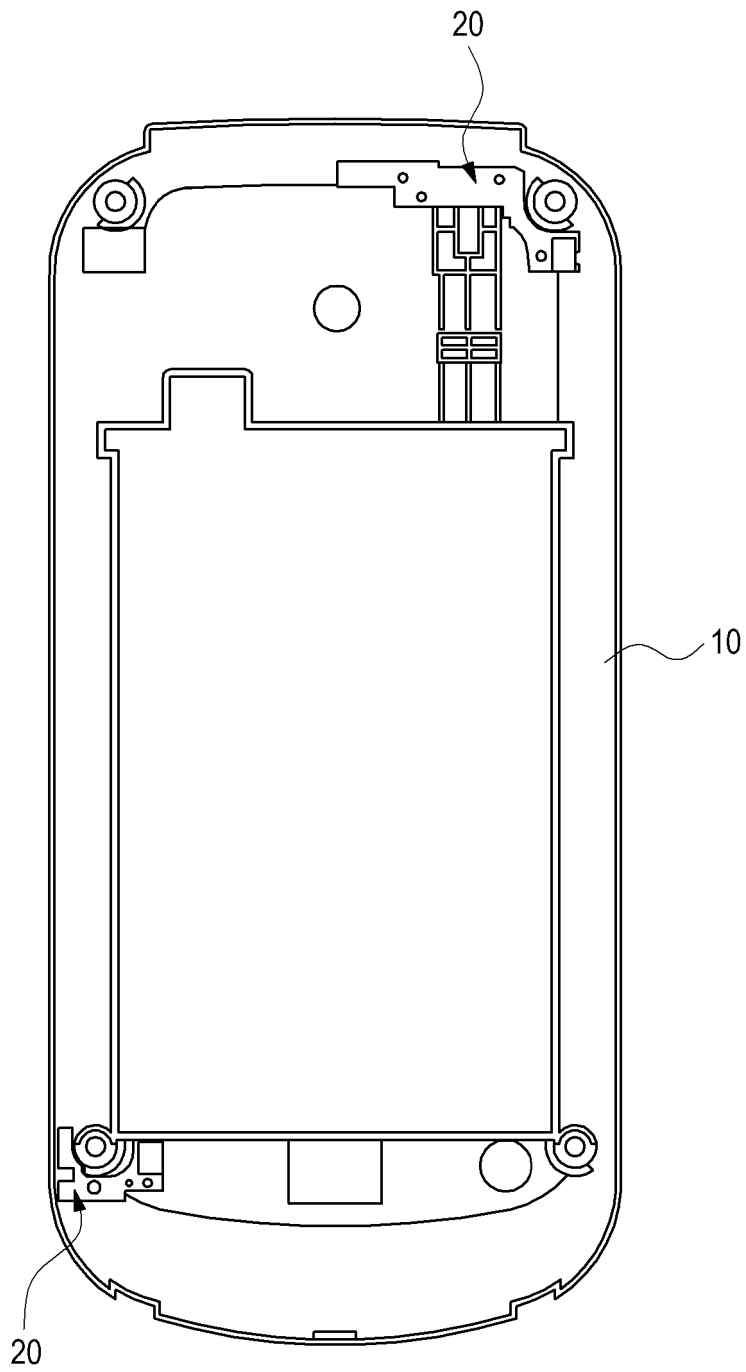


FIG.6

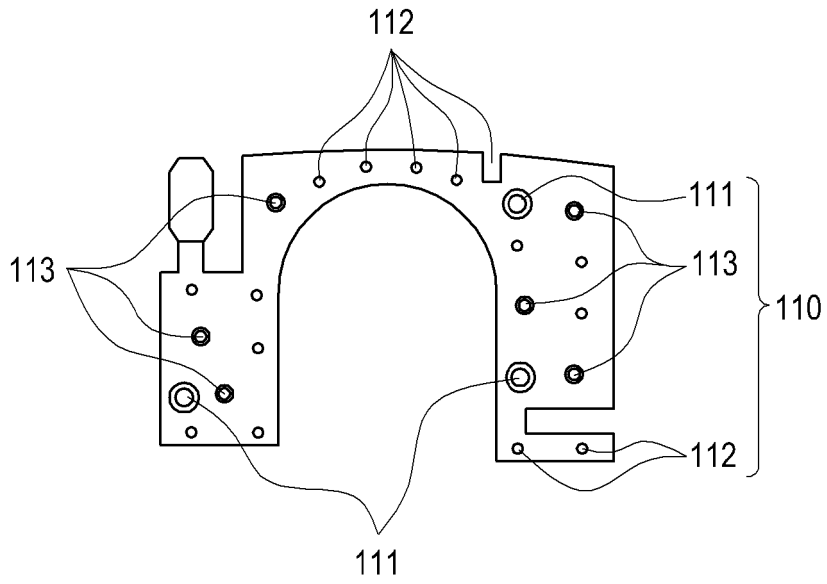


FIG. 7

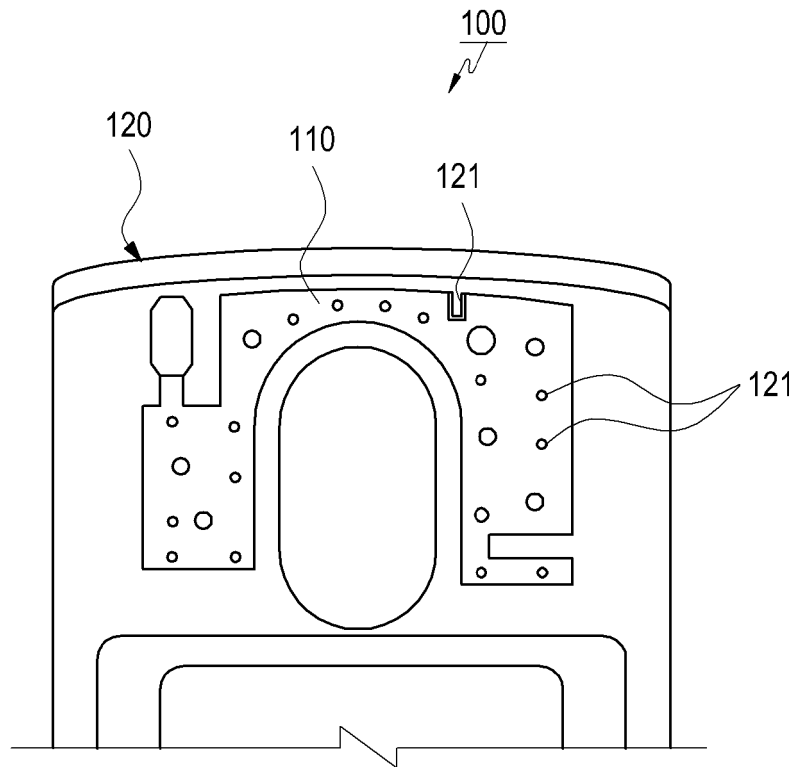


FIG. 8

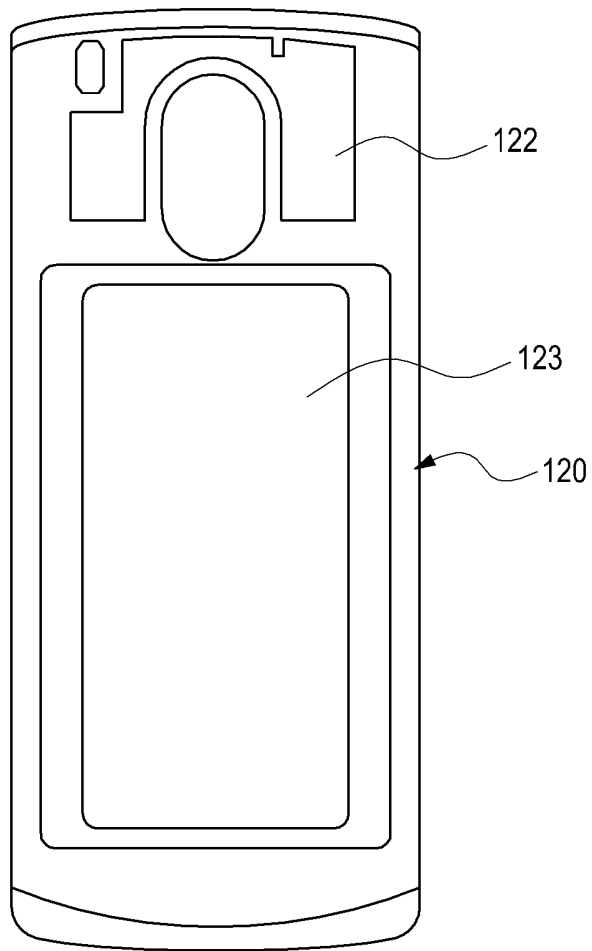


FIG. 9

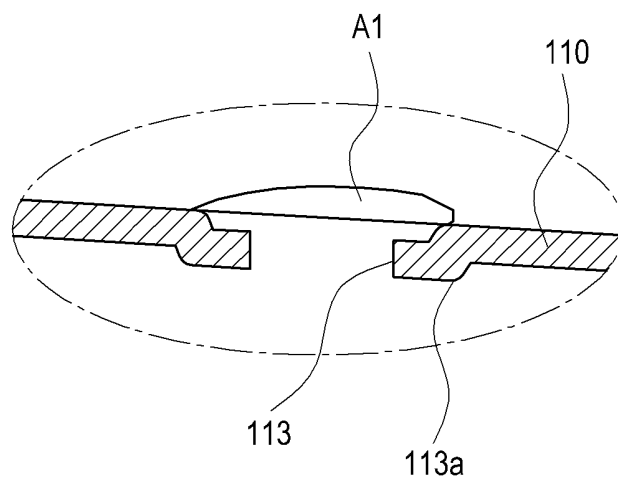


FIG. 10

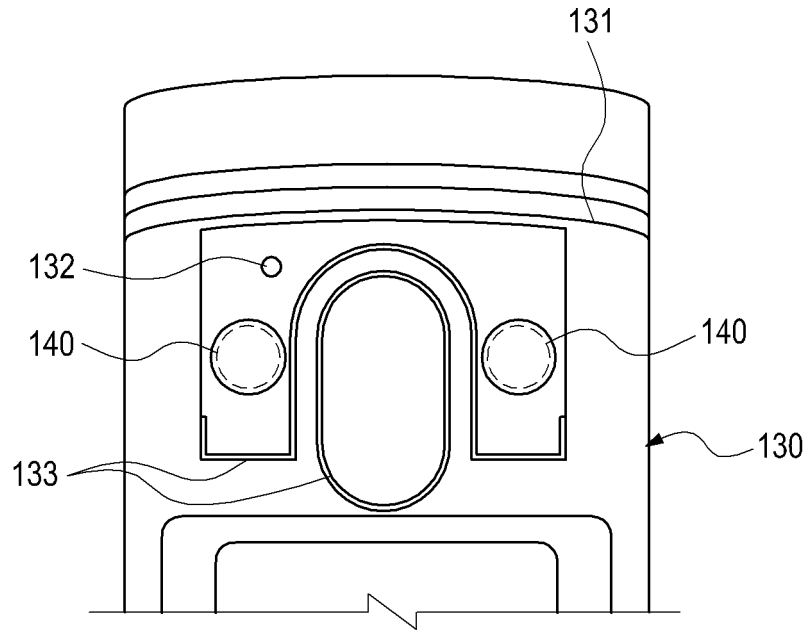


FIG. 11

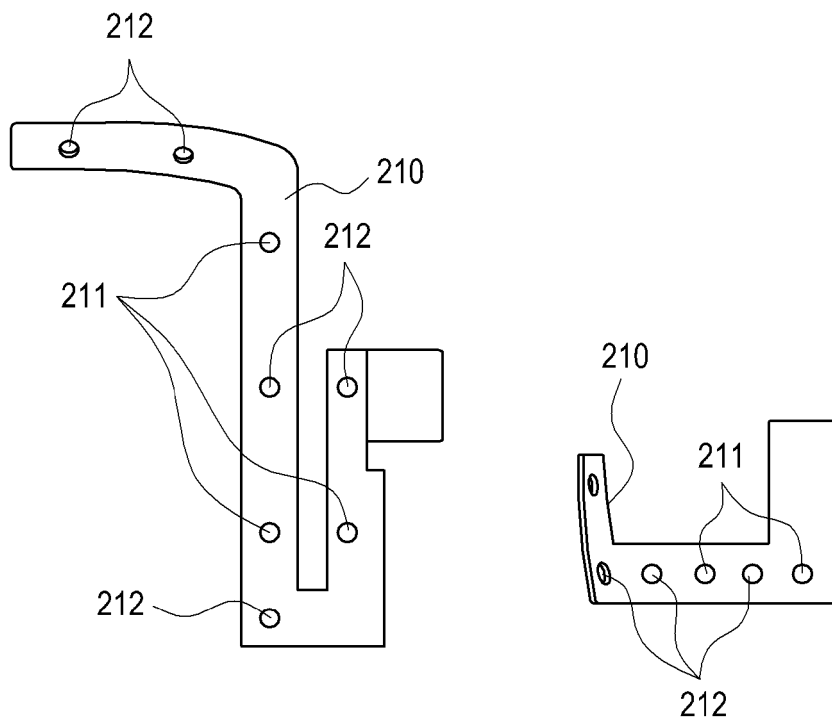


FIG. 12

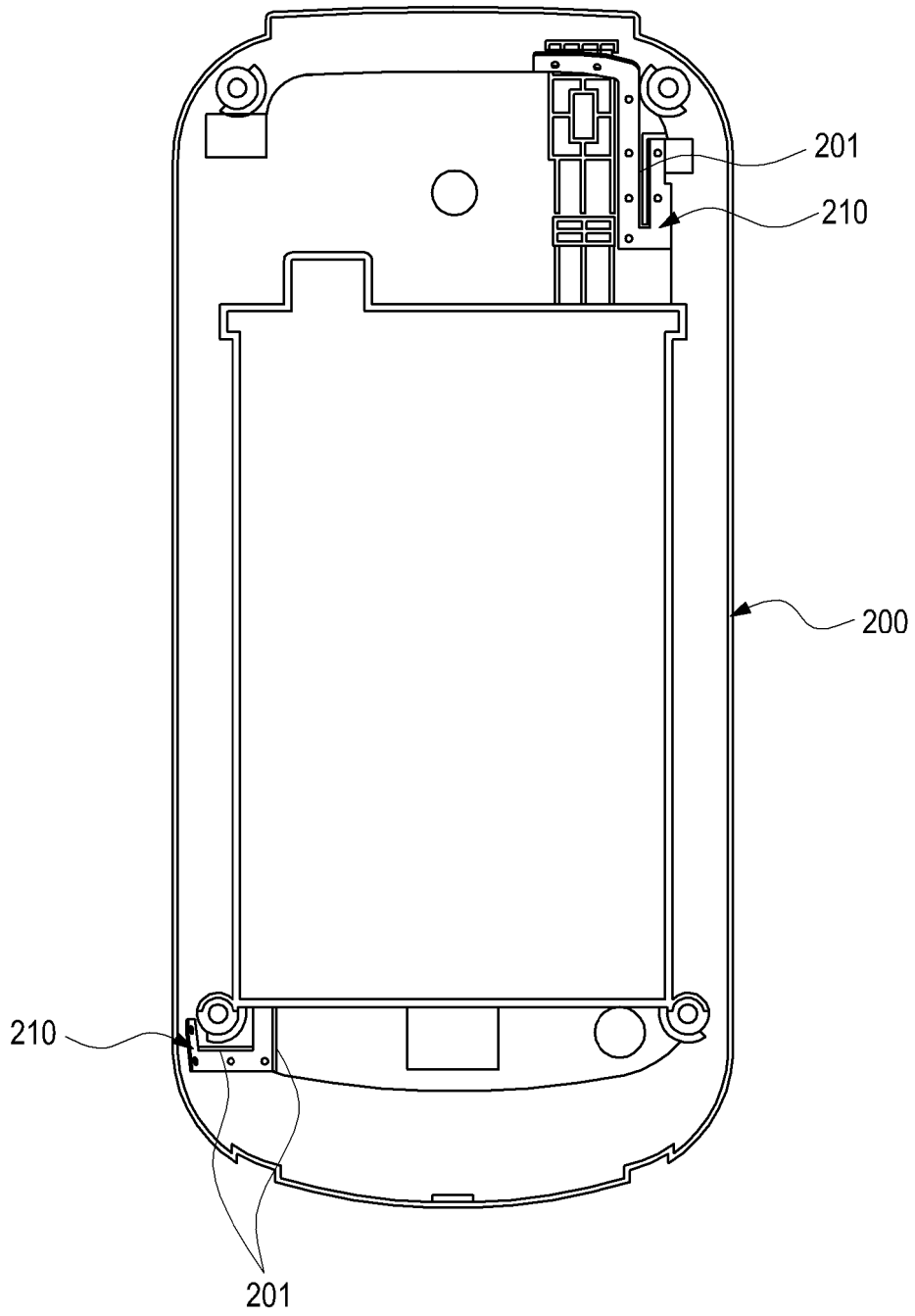


FIG.13

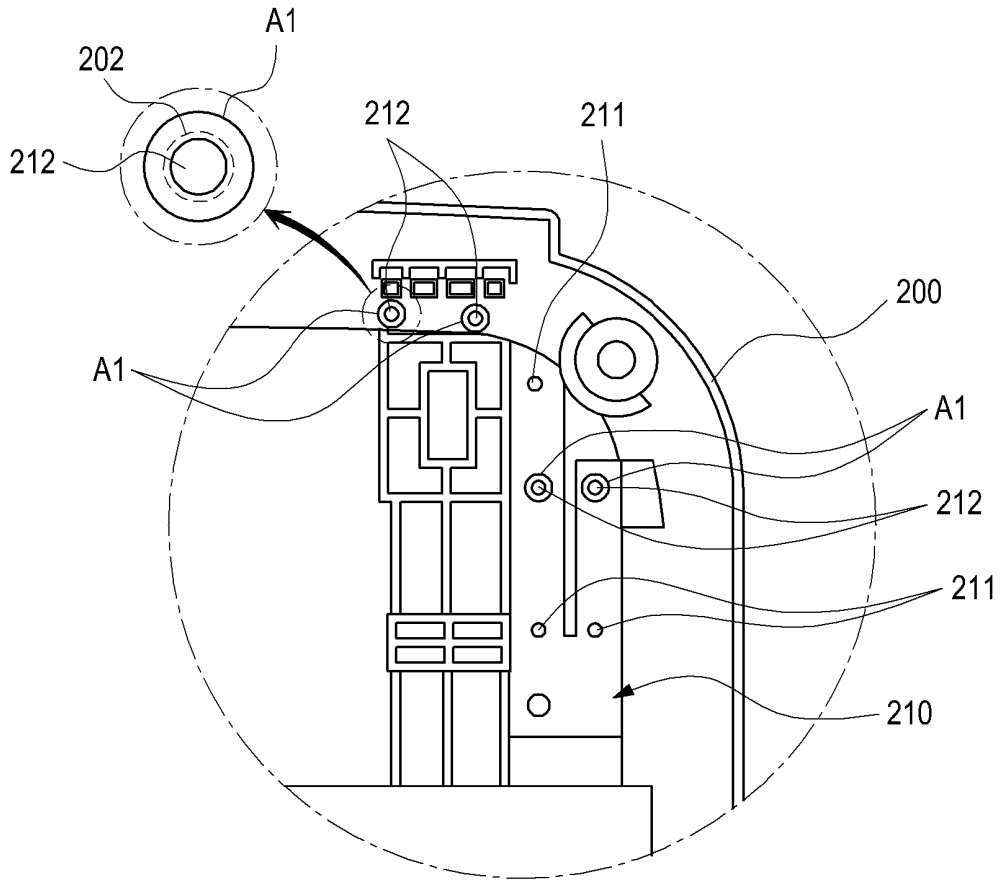


FIG. 14

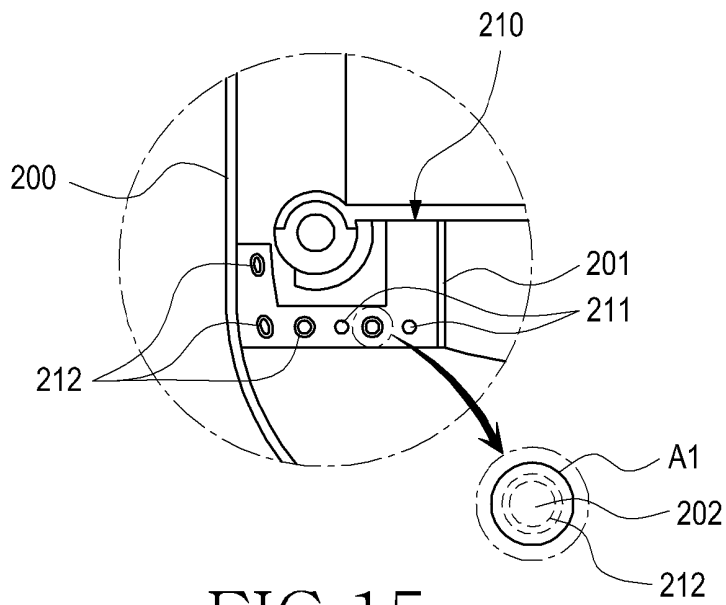


FIG. 15

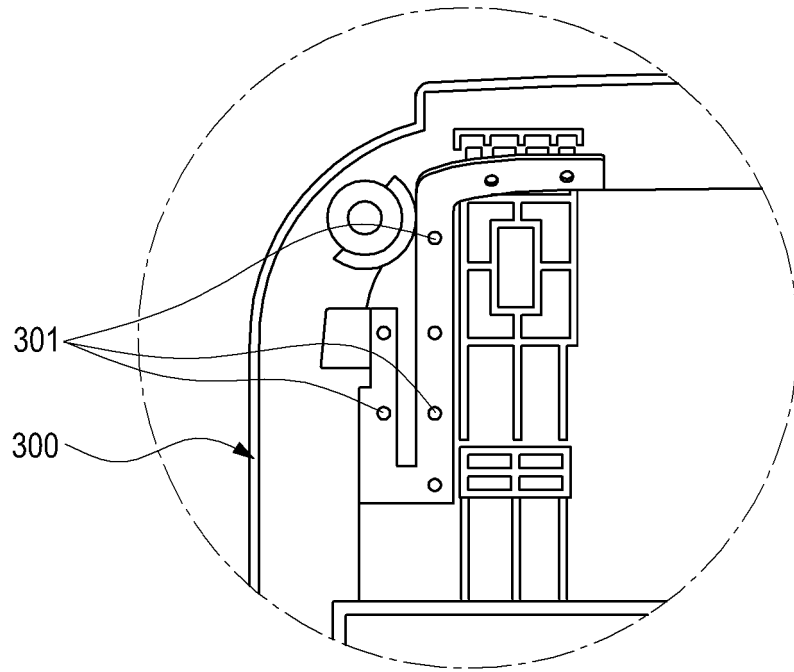


FIG. 16

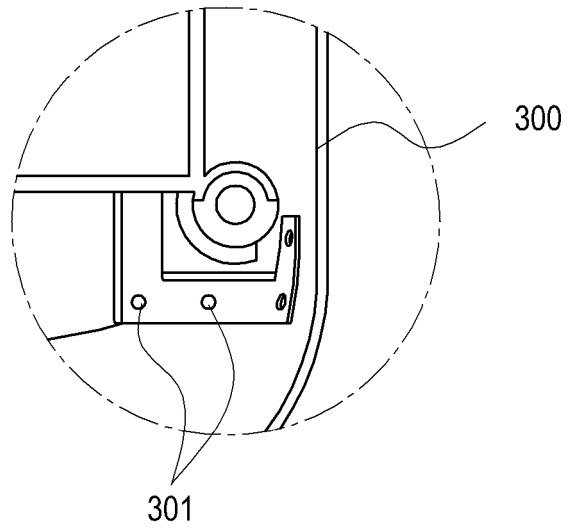


FIG. 17

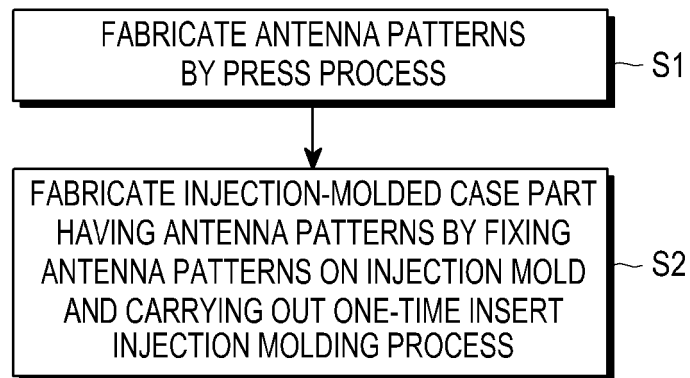


FIG.18

REFERENCES CITED IN THE DESCRIPTION

This list of references cited by the applicant is for the reader's convenience only. It does not form part of the European patent document. Even though great care has been taken in compiling the references, errors or omissions cannot be excluded and the EPO disclaims all liability in this regard.

Patent documents cited in the description

- US 2010039347 A1 [0011]
- US 2009322629 A1 [0012]